


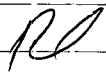




Work Order ID 64333

Thursday, December 02, 2010 1:38:42 PM


Page 1

Item ID:	D4106-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Crew Door Doulber, LH				Stop	
Start Date:	12/2/2010	Start Qty:	4.00			
Required Date:	12/15/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:		Date:	10-12-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4106	A								

100		0.00							
									
Waterjet		0.00							
FLOW CNC Waterjet									
304 .050									
	Memo								
	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								

1310-12-17

(4)

110		0.00							
									
QC		0.00							
Quality Control									
	Memo								
	QC2- Inspect parts off machine FAI/FAIB								

1310-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64333

Thursday, December 02, 2010 1:38:42 PM

Page 2

Item ID: D4106-3

Accept

Revision ID:

Item Name: Crew Door Doulber, LH

Start Date: 12/2/2010 Start Qty: 4.00

Required Date: 12/15/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



8/10/12/17

QC

Memo

0.00

Quality Control

(x4)

130

Memo
1- C'sink holes as per dwg

0.00



0.00

Small Fab

Small Fab

8/5/10/12/21 (x)

140

QC5- Inspect part completeness to step on W/O

0.00



8/10/12/21

QC

Memo

0.00

Quality Control

(x9)

-3'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 02, 2010 1:38:46 PM

Page 1

Work Order ID: 64333



Parent Item: D4106-3



Parent Item Name: Crew Door Doulber, I.H

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	122.6200	0.2006	0.844632			



304/316 .050 Sheet



HB 10-12-17

Location	Loc Qty	Loc Code
MAT	96	
116135	96	
MAT20	26.62	
111743	4.75	
113062	20.77	
115389	1.1	

116135

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	641333
Description: Crew Door Doubler, LH		Part Number:	D4106-3
Inspection Dwg: D4106 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.128	✓		✓ 1802	
Ø0.375	+0.006/-0.001	.375	✓		✓	
1.16	+/-0.030	1.156	✓		✓	
2.05	+/-0.030	2.048	✓		✓	
2.86	+/-0.030	2.861	✓		✓	
3.37	+/-0.030	3.373	✓		✓	
3.48	+/-0.030	3.483	✓		✓	
3.87	+/-0.030	3.871	✓		✓	
4.57	+/-0.030	4.570	✓		✓	
5.07	+/-0.030	5.070	✓		✓	
5.31	+/-0.030	5.370	✓		✓	
1.00	+/-0.030	1.002	✓		✓	
1.85	+/-0.030	1.846	✓		✓	
2.37	+/-0.030	2.37	✓		✓	
2.72	+/-0.030	2.719	✓		✓	
0.254	+/-0.010	.254	✓		✓	
3.20	+/-0.030	3.202	✓		✓	
0.508	+/-0.010	.507	✓		✓	
3.35	+/-0.030	3.351	✓		✓	
3.99	+/-0.030	3.988	✓		✓	
4.57	+/-0.030	4.576	✓		✓	
0.25	+/-0.030	.249	✓		✓	
0.25	+/-0.030	.250	✓		✓	
1.04	+/-0.030	1.043	✓		✓	
1.84	+/-0.030	1.840	✓		✓	
2.45	+/-0.030	2.449	✓		✓	
2.63	+/-0.030	2.631	✓		✓	
2.94	+/-0.030	2.942	✓		✓	
3.42	+/-0.030	3.427	✓		✓	
3.97	+/-0.030	3.934	✓		✓	
4.03	+/-0.030	4.033	✓		✓	
4.21	+/-0.030	4.219	✓		✓	
4.71	+/-0.030	4.712	✓		✓	
4.79	+/-0.030	4.791	✓		✓	
5.01	+/-0.030	5.01	✓		✓	
5.13	+/-0.030	5.13	✓		✓	
5.67	+/-0.030	5.671	✓		✓	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	04333
Description: Crew Door Doubler, LH	Part Number:	D4106-3
Inspection Dwg: D4106 Rev: A		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>B</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>10-12-17</u>	Date: <u>10/12/17</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ 	

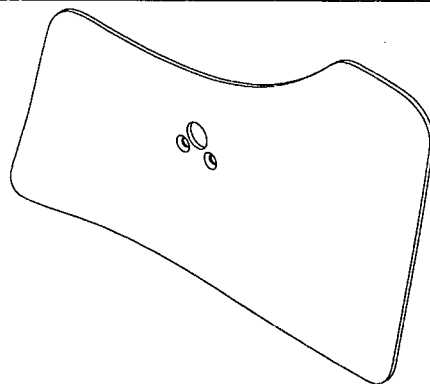
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

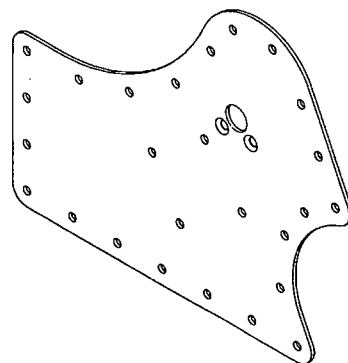
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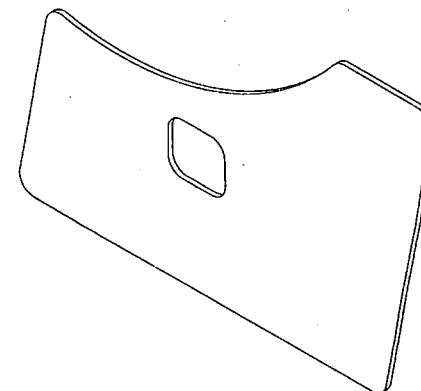
NOTE: Date & initial all entries



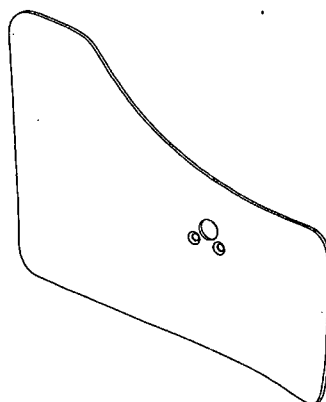
D4106-1 SILL DOUBLER, LH



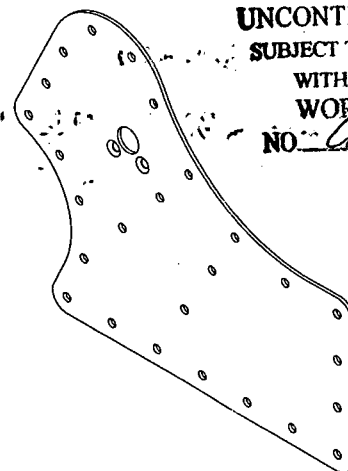
D4106-3 CREW DOOR DOUBLER, LH



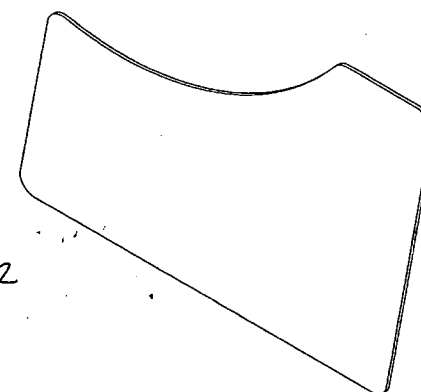
D4106-5 SPACER, SILL DOUBLER



D4106-2 SILL DOUBLER, RH



D4106-4 CREW DOOR DOUBLER, RH



D4106-7 TEMPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 441333

PS10-122

RELEASED
2010-09-23
MT

A	NEW ISSUE	JPH	10.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4106	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS	NTS
DATE	10.07.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

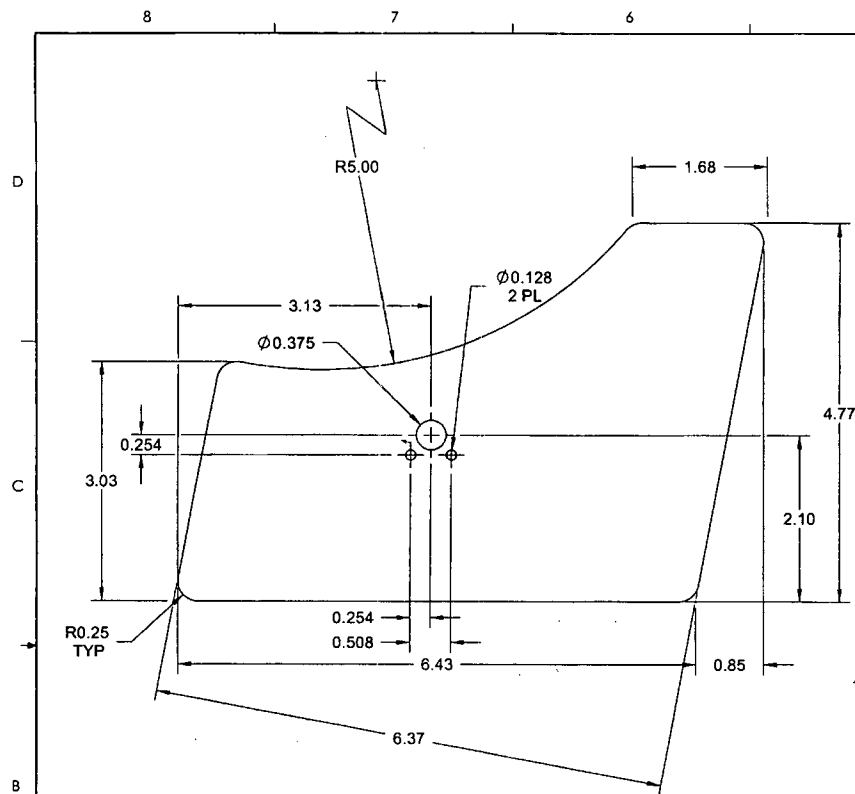
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

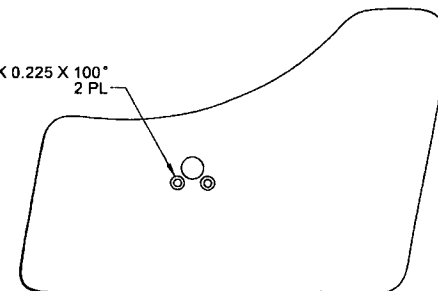
NOTE: Date & initial all entries



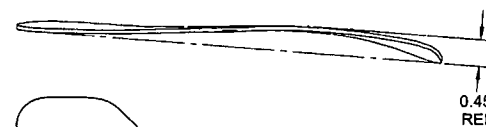
D4106-1F FLAT PATTERN, SILL DOUBLER



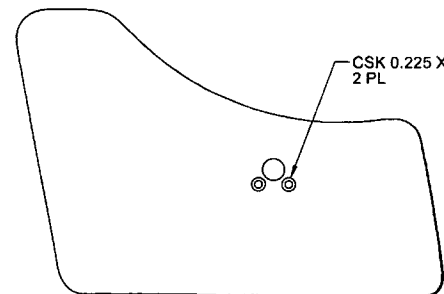
CSK 0.225 X 100°
2 PL



D4106-1 SILL DOUBLER, LH
(MAKE FROM D4106-1F)



CSK 0.225 X 100°
2 PL



D4106-2 SILL DOUBLER, RH
(MAKE FROM D4106-1F)

RELEASE
2010-09-13

- NOTES:**
- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S18GA OR M303S18GA
 - 1 & -2: MAKE FROM D4106-1F.
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
 - 7) WEIGHT -1 & -2: 0.34 lbs
 - 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1
DT9647 FOR D4106-2

w/o 44333

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4106	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS	NTS
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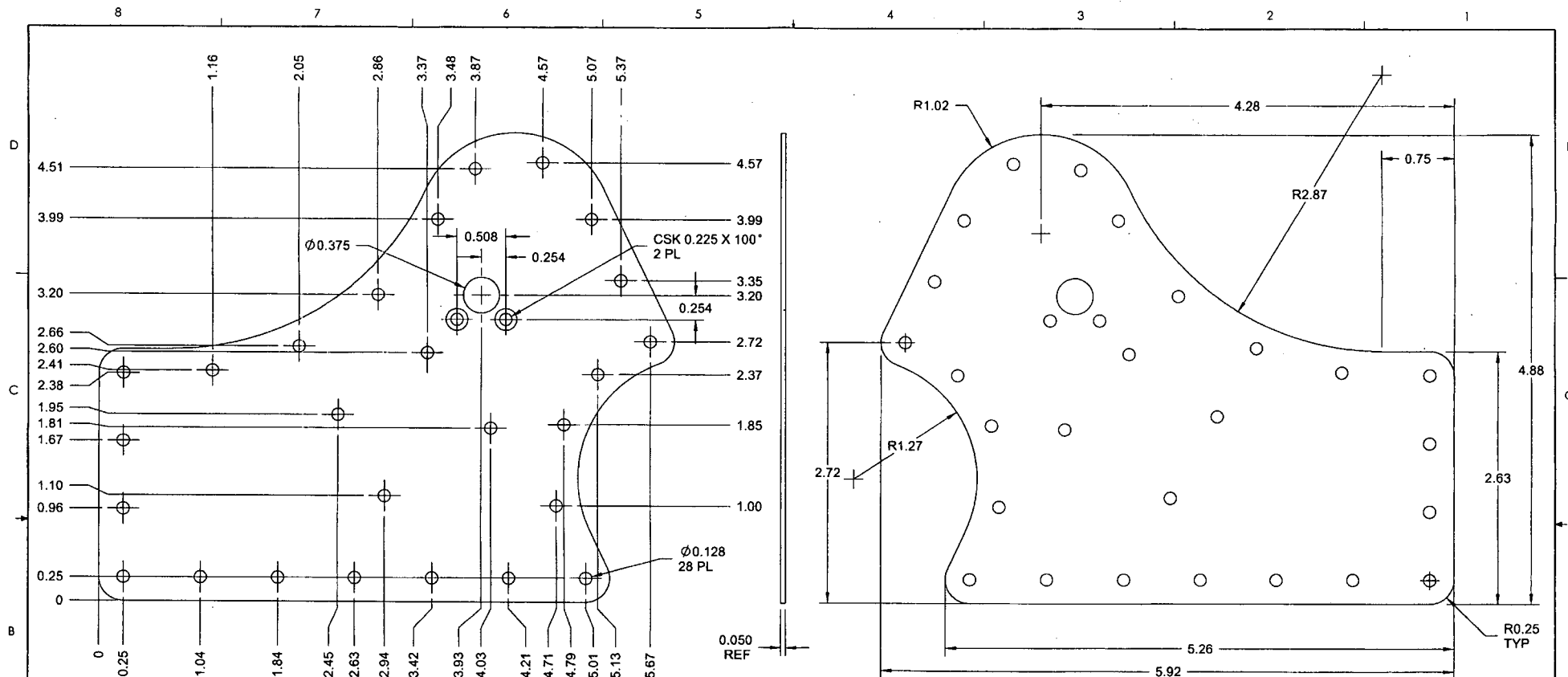
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4106-3 CREW DOOR DOUBLER, LH

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
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DATE	10.07.15		

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2010-09-23

W1064333

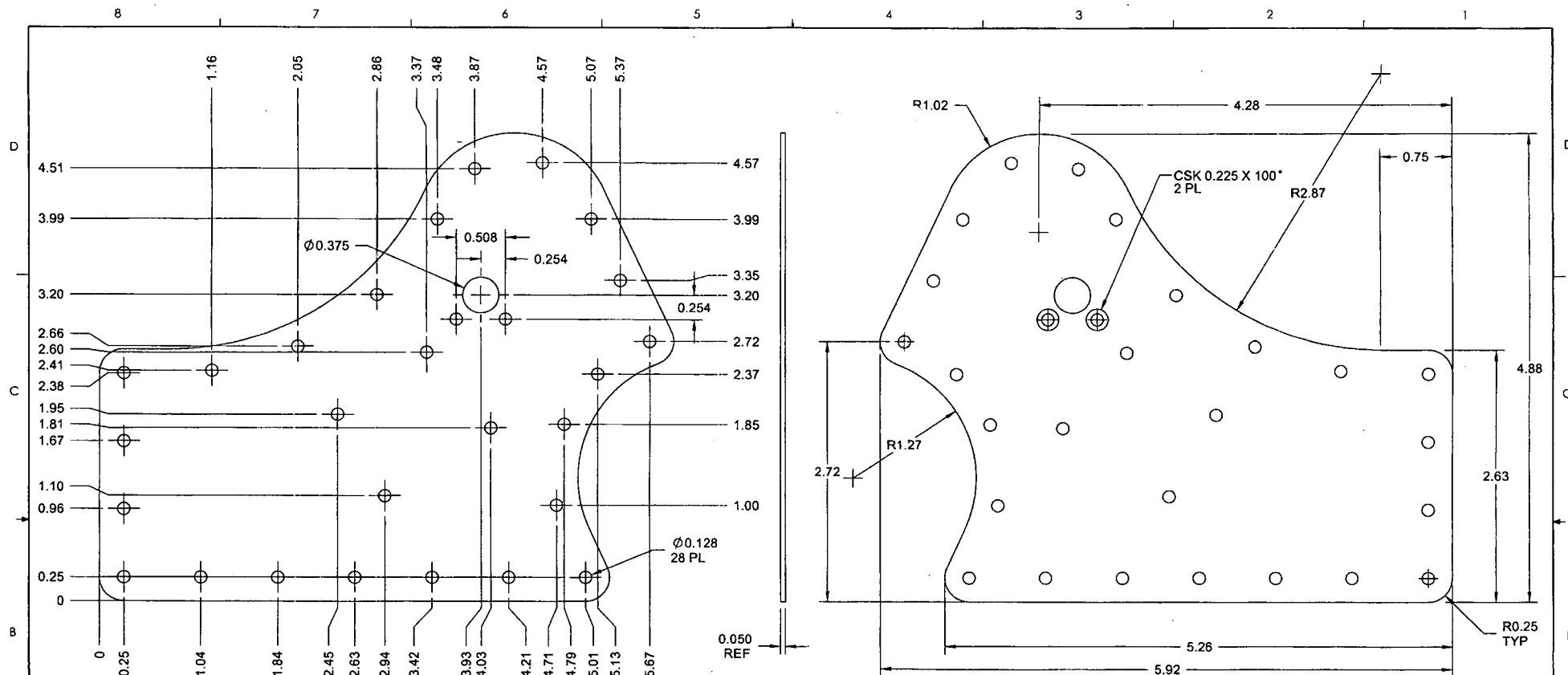
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4106-4 CREW DOOR DOUBLER, RH

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 5	
APPROVED	<i>[Signature]</i>	TITLE DOUBLERS	SCALE NTS
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DATE	10.07.15		

RELEASED
2010-09-23

u10 64323

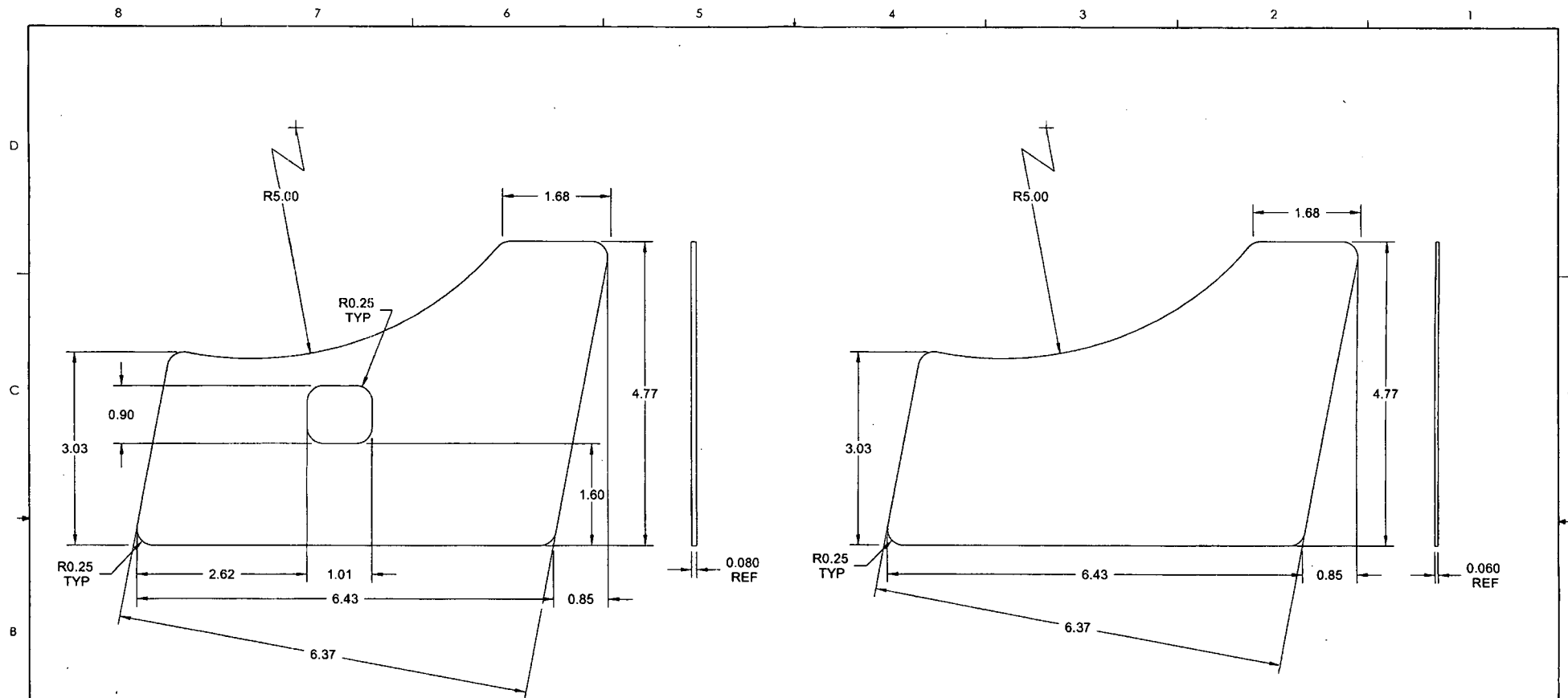
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4106-5 SPACER, SILL DOUBLER

D4106-7 TEMPLATE

NOTES:

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs
-7: N/A

W64333

RELEASED
2010-09-23
W6

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS	NTS
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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